Qty:



Wednesday, 1/30/2008 7:56:56 AM

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 37079 - 2

Estimate Number

P.O. Number

This Issue

: 1/30/2008

S.O. No. :

Prsht Rev. First Issue : NC : 11

Type

: MACHINED PARTS

Previous Run

Written By Checked & Approved By

Comment

: Est.

est

Est

07.05.14

rev c dwa 07.12.12

Rev D dwg EC veryfied by:DD

New issue KJ/JLM

Drawing Name

: SHORT PIN BRACKET

Part Number

: D333013

Drawing Number

 D3330 REV D : N/A

Project Number : D **Drawing Revision**

Material

: 2/18/2008 Due Date

Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

M1010B2500X01000

1010-1025 Steel Bar

Comment: Qty.:

0.4485 f(s)/Unit Total:

8.9691 f(s)

1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B2.500x01.000) Identify for D3330-13 Batch: M 10222

20

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 2.500" x 1.000" x 3.00" long (+/-0.030)

3.0

40

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA480 and Dwg D3330

Identify as D3330-13

Deburr

QC2

INSPECT PARTS AS THEY COME OF

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Wednesday, 1/30/2008 7:56:57 AM Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT PIN BRACKET

Job Number: 37079

Part Number: D333013

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SECOND CHECK

Comment: SECOND CHECK

6.0

PACKAGING 1

PACKAGING RESOURCE #1

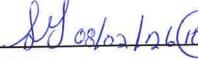
Comment: PACKAGING RESOURCE #1

Identify and Stock



Location: VA

FINAL INSPECTION/W/O RELEASE



7.0 QC21





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/2/26



DART AEROSPACE LTD	Work Order:	37079
Description: Short Pin Bracket	Part Number:	D3330-13
Inspection Dwg: D3330 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	+/-0.030	3.995	/			
2.625	+/-0.010	2.635	/			
0.260	+/-0.010	. 258	1			
Ø0.594	+0.005/-0.000	2076	./			
0.625	+/-0.010	. 528	V			
0.500	+/-0.010	,505	/		12)	
2.25	+/-0.030	2.255	1			
Ø0.531	+0.005/-0.000	.531	V			
0.950	+/-0.010	.949				
Ø0.348	+0.005/-0.000	.349	1			
Ø 0.467	+/-0.010	970	1			
1.250	+/-0.010	1.251	1			
1.00	+/-0.030	1.00	/			
0.10 x 45°	+/-0.030	.108	1			
Ø0.516	+0.005/-0.000	.520	1			
			97577		43333	
			1			
				-		

Measured by:	X P	Audited by:	and	Prototype Approval:	NIA
Date:	2-1-175	Date:	40/12/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.05.10	New Issue	KJ/JLM	ripprovou
В	06.03.09	Dwg Rev updated	KJ/JLM	
		Dwg Rev updated	KJ/EC K	12
	- a		I NOTEC OX	a